

535

Split A

DART AEROSPACE LTD	Work Order :	23925
Description: Cap	Part Number:	D2855
Drawing: D2855 Rev. A	Qty:	50 100

Step	Location	Procedure	By	Date	Qty								
1	EXPEDITING	Issue Work Order	AK	05/08/05	100								
2	PURCHASING	Issue P/O: <u>200843</u> Cast per Dwg D2855 Material release note required	AK	05/08/05	100								
3	RECEIVING	Receive and ensure material note is attached	CL	05/09/23	100								
4	QC	Inspect Level 6 Ensure material release note is attached	AK	05-10-04	100								
5	METAL	Drill as per Dwg D2855 using DT 8235 Open holes to 19/64"	SB	05/10/05	100								
6	METAL	Deburr and Turn	SB	05/10/05	100								
7	QC	Inspect Level 7	AK	05-10-05	100								
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	MM	05/11/17	50								
9	QC	Inspect Level 3	CL	05/11/17	50								
10	STORES	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>ALS7-1032-225 or AKS7-1032-225 or ALS4-1032-225 or — AKS4-1032-225</td><td>Insert</td><td>M14576</td></tr></table>	Qty	Part Number	Description	Batch	2	ALS7-1032-225 or AKS7-1032-225 or ALS4-1032-225 or — AKS4-1032-225	Insert	M14576	MM	05/11/17	50
Qty	Part Number	Description	Batch										
2	ALS7-1032-225 or AKS7-1032-225 or ALS4-1032-225 or — AKS4-1032-225	Insert	M14576										
11	METAL	Install Inserts as per Dwg D2855	EC	05/11/17	50								
12	QC	Inspect Level 7	MM	05/11/17	50								
13	STORES	Identify and Stock	MM	05/11/17	50								
14	EXPEDITING	Close W/O Cost / Part <u>14.65</u> <u>545</u> <u>05/11/21</u> <u>(50)</u> <u>14.60</u>											

PTO

Rev	Date	Change	Revised By	Approved
A	99.01.04	New Issue (was D2575 Rev. E)	DM	
B	00.06.22	Added receiving step & removed P/O for powder coat	EC	

RELEASED

EC JUN 26 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-10-05	6	Tumble not required for aft caps. Remove permanent change <i>[Signature]</i>	<i>[Signature]</i>	6-11-22			<i>[Signature]</i> 05-10-05

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/11/22

NOTE: Date & initial all entries

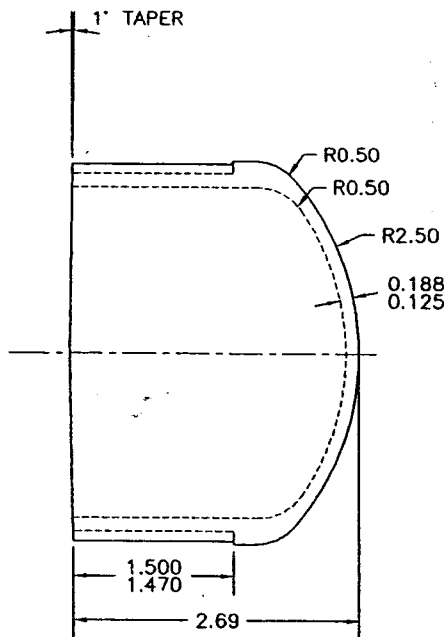
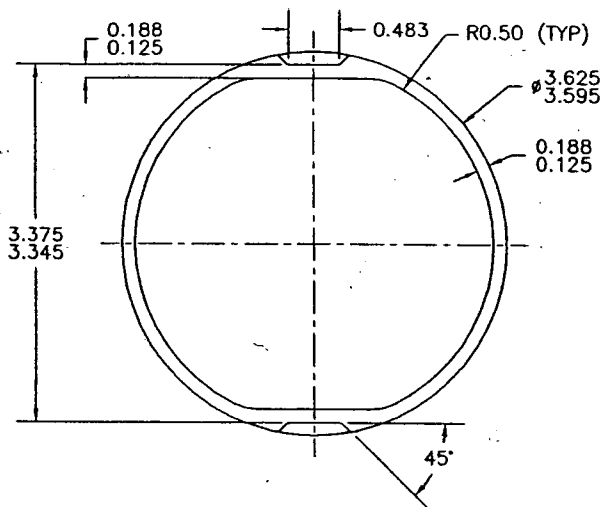
QA: N/C Closed: _____ Date: _____



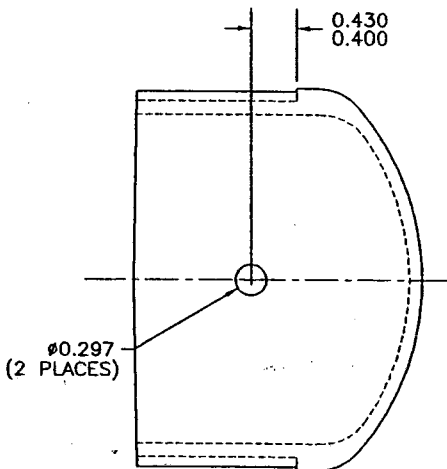
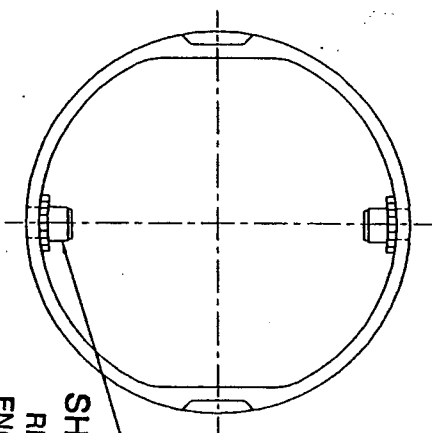
DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2855	SHEET 1 OF 1
DATE	98.12.12	TITLE	CAP	NEW ISSUE (WAS D2575 REV. E)	SCALE N/A
A	96.12.12				

RELEASED
98.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23925

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No	: 0023925	Department Code:	
Project Name	: D2855	Burden Flags	: NNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2855	Invoice Number	:
Description	: Cap	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 100	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-02-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Ann. Jy. Gire

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL (514) 631-1331 FAX (514) 631-8448

Expédié à
Shipped

DART AERO SPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing

Date: **21/09/2005** Slip No. **5482**

Hawkesbury, ON, K6A 1K7

Votre No. Commande **2008431**

Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No Our No.	Spécifications	Note d'autorisation Incoming Release note
100	DRWG D 2865 rev A	Z098046	A356.2	B#0525901 ingot #813159

Analyse
Analysis (as in ingot)

(Si)	6.8%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100

Job Costing Report ✓

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:44 am

Work Order No : 0023925
Project Name : D2855
Project For : WK535
Work Order Type : Main
Main WO Number :
House Part Number : D2855
Description : Cap
Manufactured : Yes
Amount Req'd : 100
Amount Done : 50
Start Date : 08-02-05
Est Finish Date : 08-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	1239.48	100.00	629.48	610.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	10.25	100.00		
Production Cost :	0.00	209.64	100.00	104.82	104.82
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1449.12	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1449.12			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.20
Profits/(Loss) :	0.00	(-1449.12)

MIS 01/13
u
11-13

Monday, 14/11/2005 8:32:00 AM
Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CAP
Job Number	: 23925		
Estimate Number	: 10519		
P.O. Number	:	Part Number	: D2855
This Issue	: 14/11/2005 S.O. No. :	Drawing Number	: D2855 REV. A
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: _____	Due Date	: 30/11/2005 Qty: 50 Um: Each
Checked & Approved By	: _____		
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

Cast per Dwg D2855

Material Release Note Required

2.0	D2855	Cap
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS1

1- Machine as per Folio FA332 and Dwg D2576

2- Deburr

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr and Tumble

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 23925

Part Number: D2855

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

ALS71032225

INSERT

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

